

Work Order ID 104442

\*104442\*

Page 1

July-11-13 10:41:19 AM

Item ID: D4027-041

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Hose Clamp Assembly

Stop

\*NS2\*

Start Date: 7/11/13 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 7/18/13 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan:

*(initials)*

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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D4027	A	0.00							
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100		0.00							
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\*100\*

Small Fab	Memo	0.00							
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Small Fab	Drill hole and assemble as per dwg notes								
-----------	--	--	--	--	--	--	--	--	--

*FF*  
*4 4* 13-08-28

110	QC5- Inspect part completeness to step on W/O	0.00	<i>27</i> <i>13.8.29</i>						
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\*110\*

QC	Memo	0.00							
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Quality Control

*4*

120	Identify as per dwg & Stock Location: <i>ST242B</i>	0.00							
-----	---	------	--	--	--	--	--	--	--

\*120\*

Packaging	Memo	0.00							
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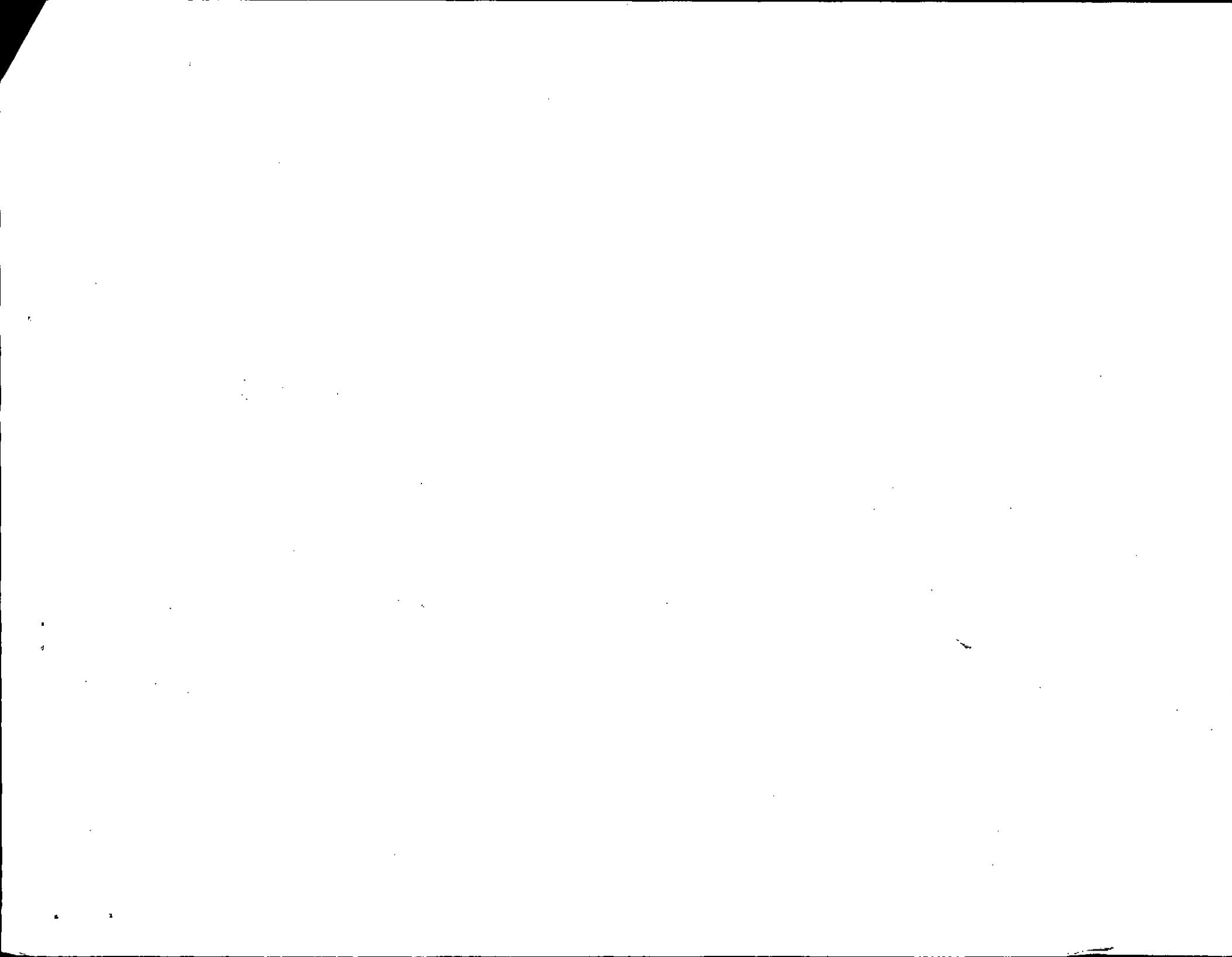
Packaging									
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*4X* 13-8-29

*SD*







# Picklist Print

July-11-13 10:41:18 AM

Page 1

Work Order ID: 104442

Parent Item: D4027-041

Parent Item Name: Hose Clamp Assembly

Start Date: 7/11/13

Required Date: 7/18/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 10.02.01 new issue Prelim EC verified by:JLM IPP Rev:B 10.05.17 as per ECN10-562 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4027-1 Hose Clamp		Manufactured	No			100	Each	6.0000	1	4		FF 13-08-28	
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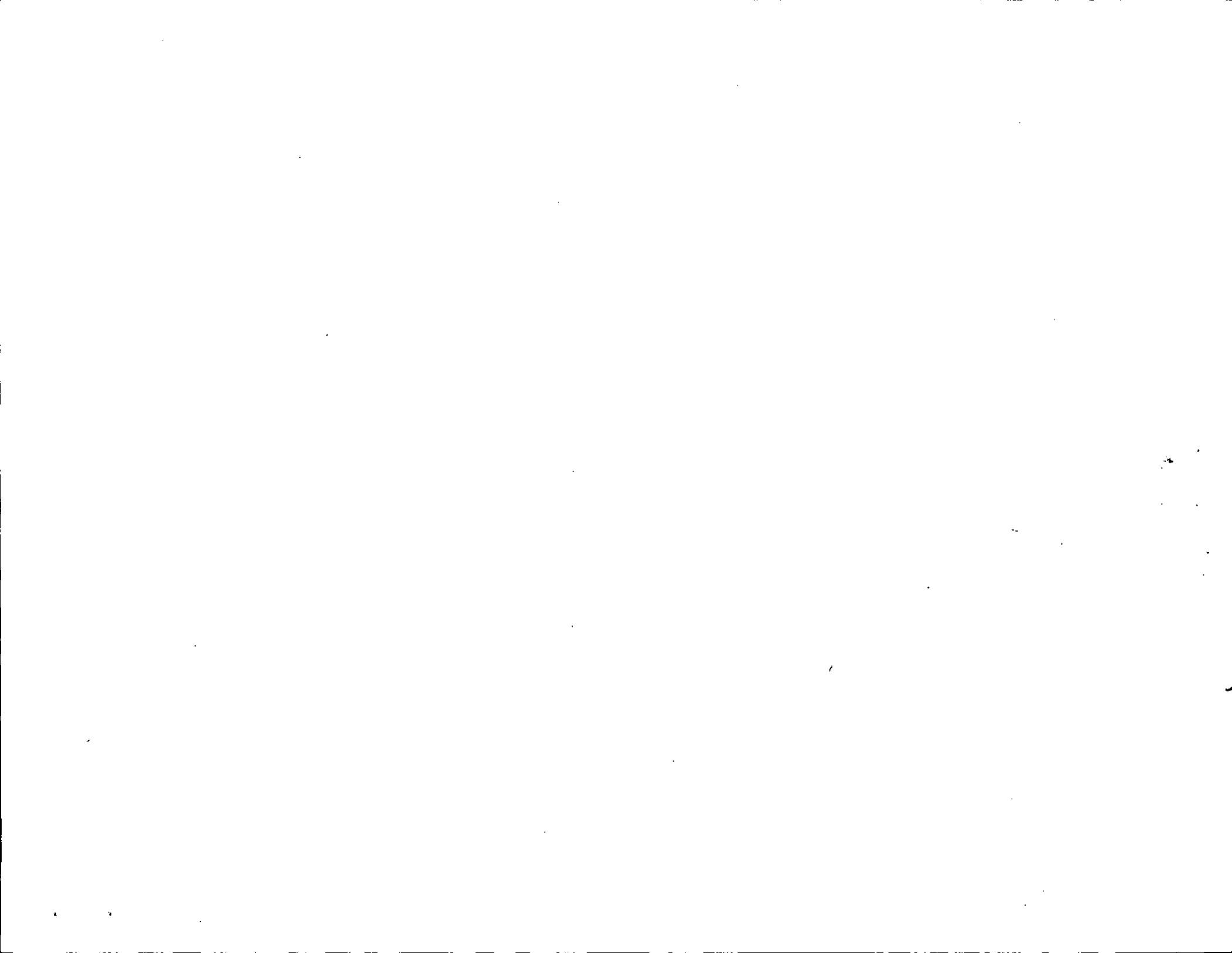
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST449	105827	6					4		
						6							
D4027-8 Rubber Cushion		Manufactured	No			100	Each	8.0000	1	4		FF 13-08-28	

				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA	83970	8					4		
						8							
AN743-13 Bracket		Purchased	No			100	Each	68.0000	1	4		FF 13-08-28	

				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST347		68						
						1						
				121825		1						
				123352		10					4	
				M126010		20						
				M126119		12						
				M126249		25						

MS24693-S28 Screw		Purchased	No			100	Each	107.0000	1	4		FF 13-08-28	
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				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST301		10						
						10						
				ST302		97						
						56					4	
						41						



# Picklist Print

July-11-13 10:41:19 AM

Page 2

Work Order ID: 104442

Parent Item: D4027-041

Parent Item Name: Hose Clamp Assembly

Start Date: 7/11/13

Required Date: 7/18/13

Start Qty: 4.00

Required Qty: 4.00

NAS1149DN632J

Purchased

No

100

Each

655.0000

1

4

FF 13-08-28

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST293 126254	605	7
123900	5	
MI26084	600	
ST510a	50	
125646	50	

MS21042L02

Purchased

No

100

Each

0.0000

1

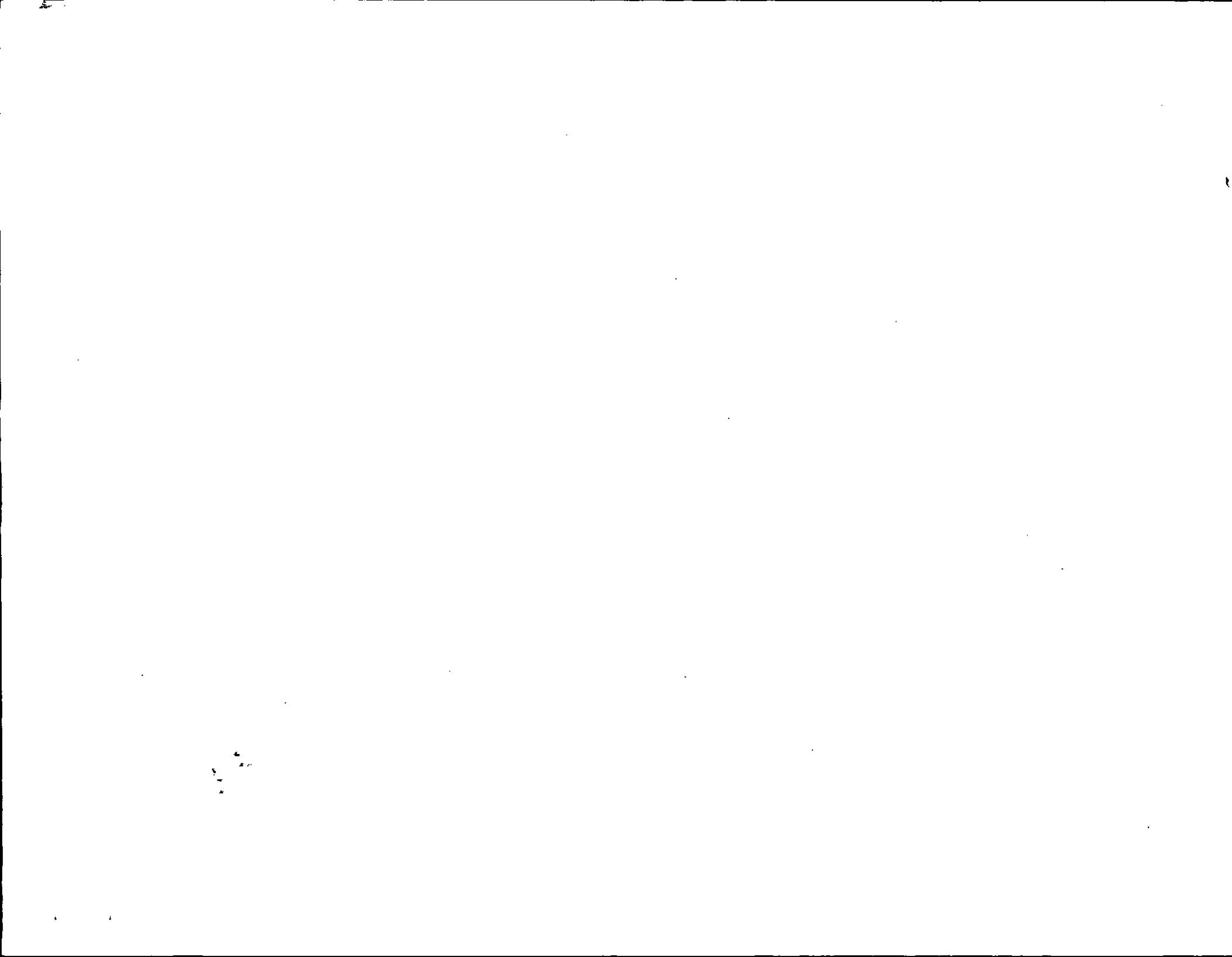
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Nut

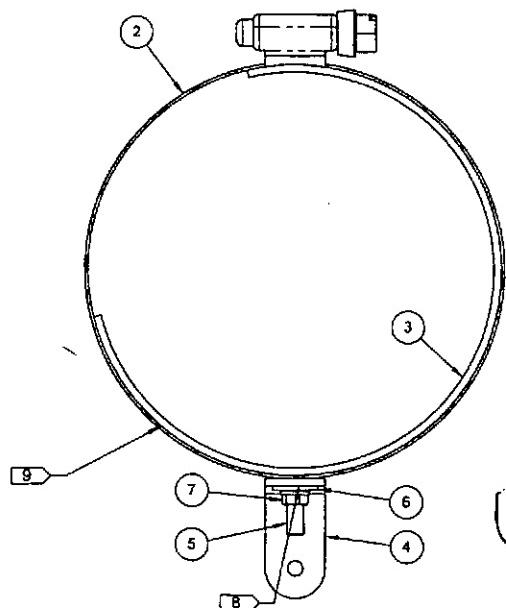
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13.08.28

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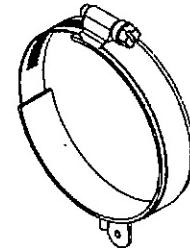
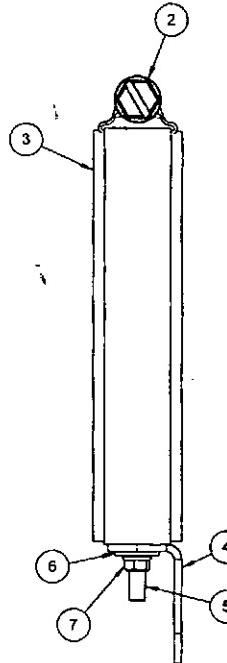
FF 13-08-28



ITEM NO.	QTY. 041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4027-041	VENT CLAMP ASSEMBLY	JCA-M47-2-20
2	1	D4027-1	HOSE CLAMP	
3	1	D4027-5	RUBBER CUSHION	
4	1	D4027-9	BRACKET, SUPPORT ANGLE	
5	1	MS24693S28	SCREW	
6	1	NAS1149DN632J	WASHER	
7	1	MS21042L08	NUT	

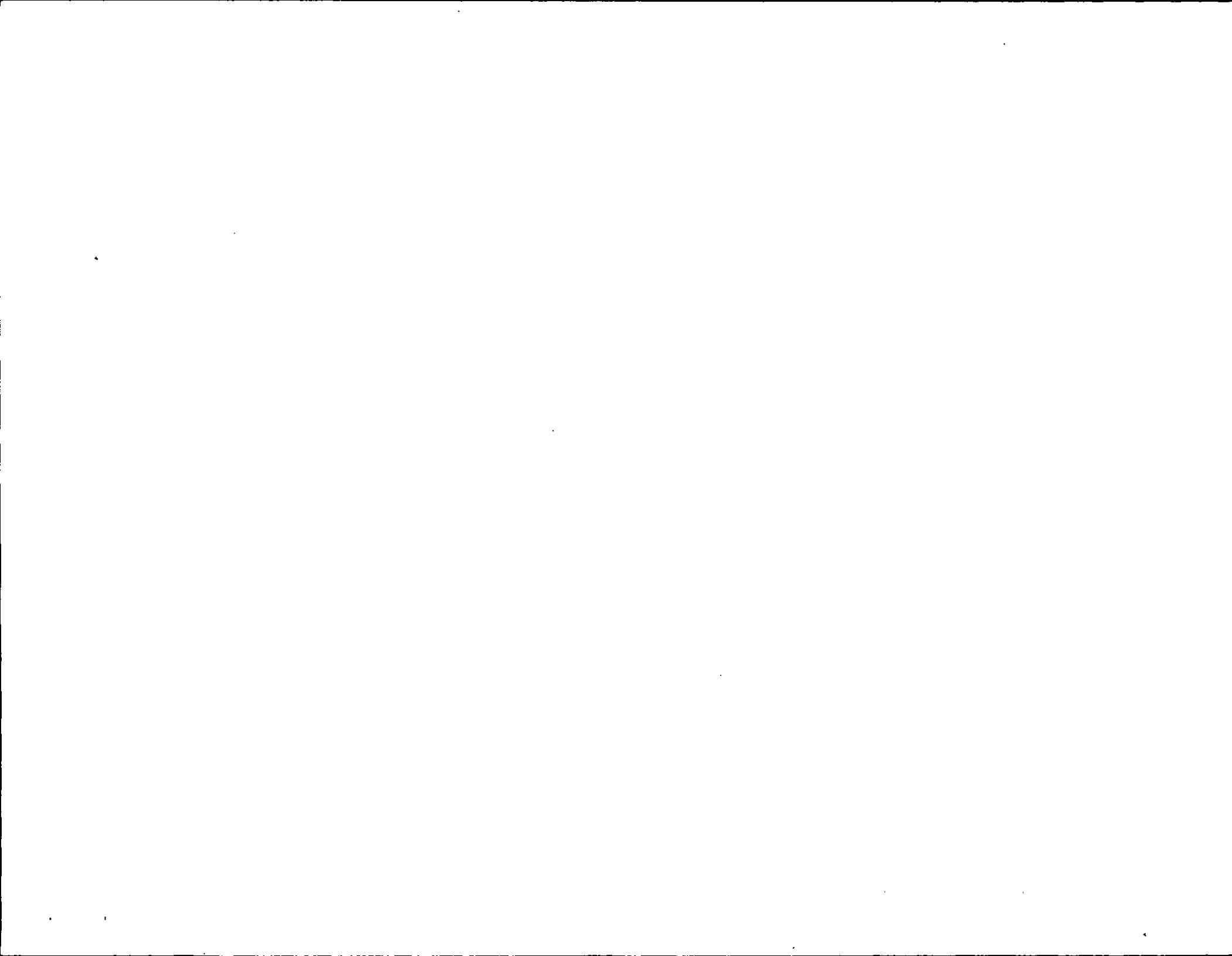


D4027-041 VENT CLAMP ASSEMBLY

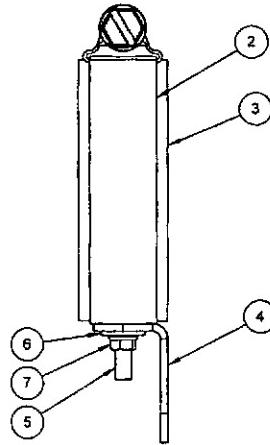
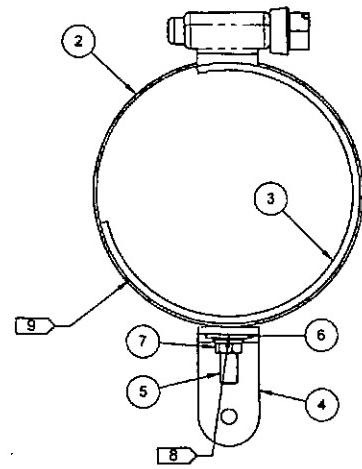


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2010-05-15  
JW

A	NEW ISSUE	10.04.16
REV.	DESCRIPTION	BY DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. D4027 REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 1 OF 7
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DE APPR.	<i>[Signature]</i>	SCALE NTS
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ITEM NO.	QTY. .043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4027-043	VENT CLAMP ASSEMBLY	JCA-M47-2-35
2	1	D4027-3	HOSE CLAMP	
3	1	D4027-7	RUBBER CUSHION	
4	1	D4027-9	BRACKET, SUPPORT CLAMP	
5	1	MS24693S28	SCREW	
6	1	NAS1149DN632J	WASHER	
7	1	MS21042L09	NUT	



D4027-043 VENT CLAMP ASSEMBLY

RELEASED  
2010-05-05  
*[Handwritten signature]*

A  
NOTES:  
1) MATERIAL: N/A  
2) FINISH: N/A

- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-043" AND B/N USING FINE POINT PERMANENT INK MARKER  
7) WEIGHT: 0.06 lbs  
8) ATTACH D4027-9 BRACKET USING MS24693S28 SCREW, MS21042L06 NUT AND NAS1149DN632F WASHER  
9) GLUE D4027-7 RUBBER CUSHION TO D4027-3 CLAMP USING 3M CONTACT CEMENT IN POSITION AS SHOWN

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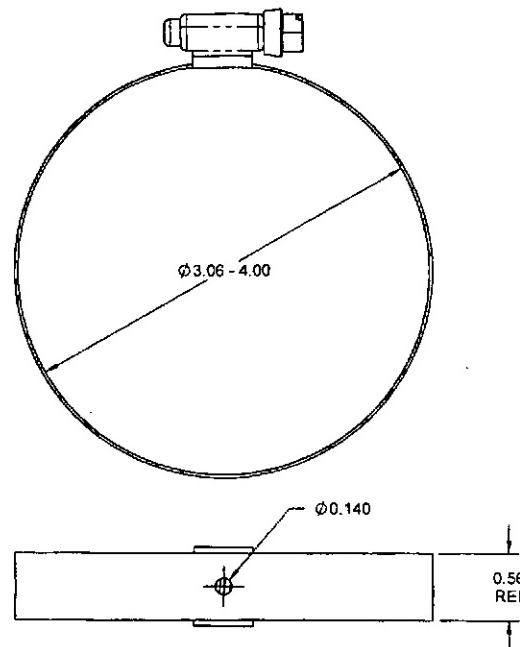
4

3

2

1

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-1	REF JCA-M47-2-20



D4027-1 HOSE CLAMP

RELEASED  
2010-05-15  
MM

A NOTES:

- 1) MATERIAL: MADE FROM QS200M56S
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-1" AND S/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs
- 8) DRILL Ø0.140 HOLE AS SHOWN OPPOSITE WORM DRIVE SCREW, DIMPLE HOLE FROM INSIDE FOR MS24693S28 SCREW

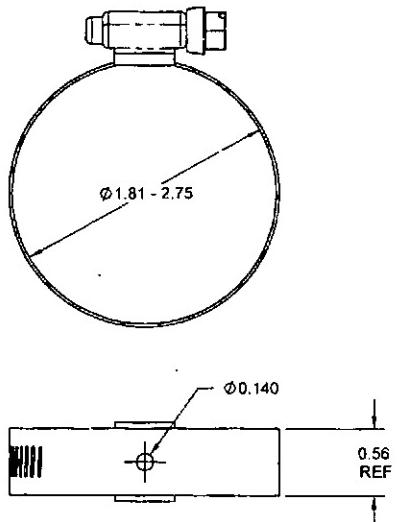
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CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	REV. A
APPROVED	<i>[Signature]</i>	D4027
DE APPR.	<i>[Signature]</i>	TITLE
DATE	10.04.16	SCALE
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8 7 6 5 4 3 2 1

DART AEROSPACE PART NUMBER D4027-3	JOHN CAMERON AVIATION PART NUMBER REF JCA-M47-2-35
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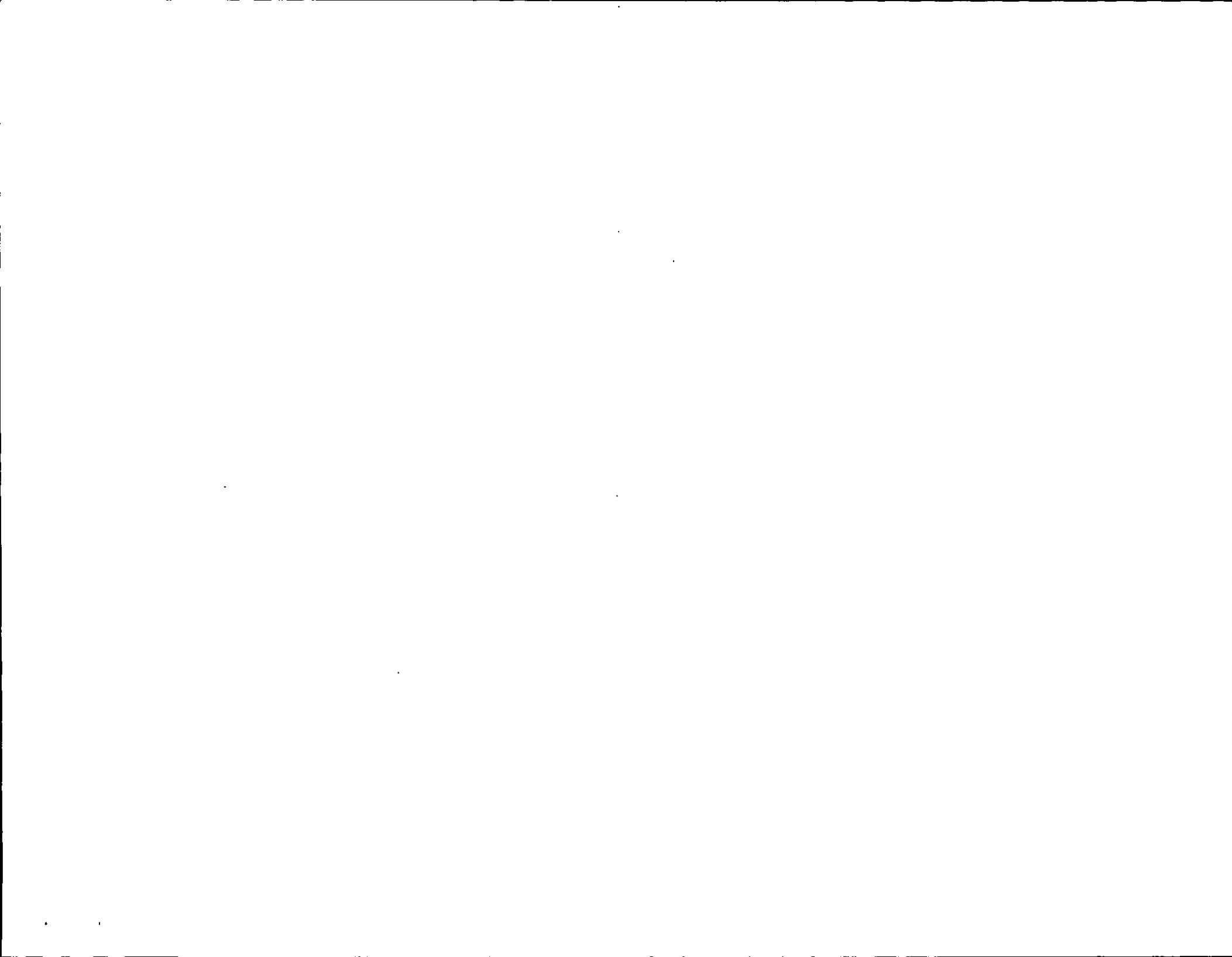
D4027-3 HOSE CLAMP

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2010-05-15  
M

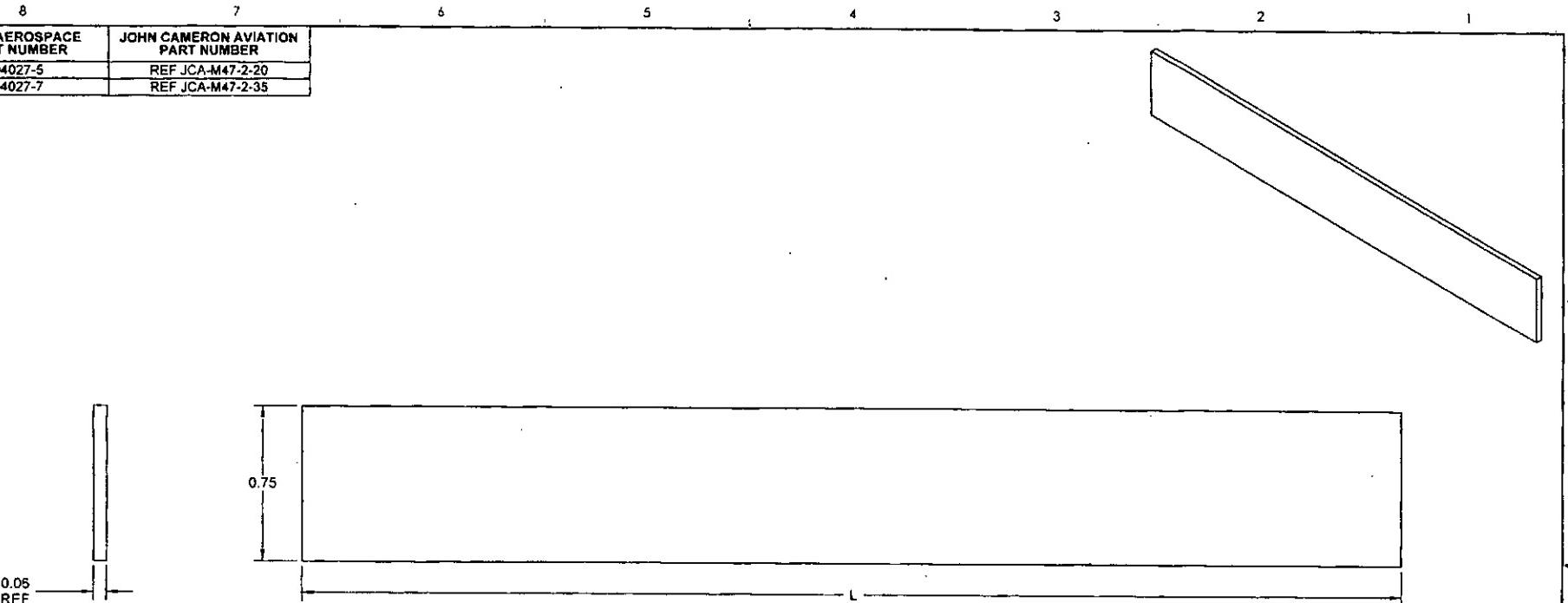
- A NOTES:
- 1) MATERIAL: MADE FROM QS200M36S
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-3" AND B/N USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.05 lbs
  - 8) DRILL Ø 0.140 HOLE AS SHOWN OPPOSITE WORM DRIVE SCREW, DIMPLE HOLE FROM INSIDE FOR MS24693S28 SCREW

DESIGN	10	DART AEROSPACE LTD
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CHECKED	10	DRAWING NO.
MFG. APPR.	10	REV. A
APPROVED	10	D4027
DE APPR.	10	SHEET 4 OF 7
DATE 10.04.16		TITLE CLAMP
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8 7 6 5 4 3 2 1



DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-5	REF JCA-M47-2-20
D4027-7	REF JCA-M47-2-35



DART PART NUMBER	LENGTH "L"
D4027-5	5.30
D4027-7	8.25

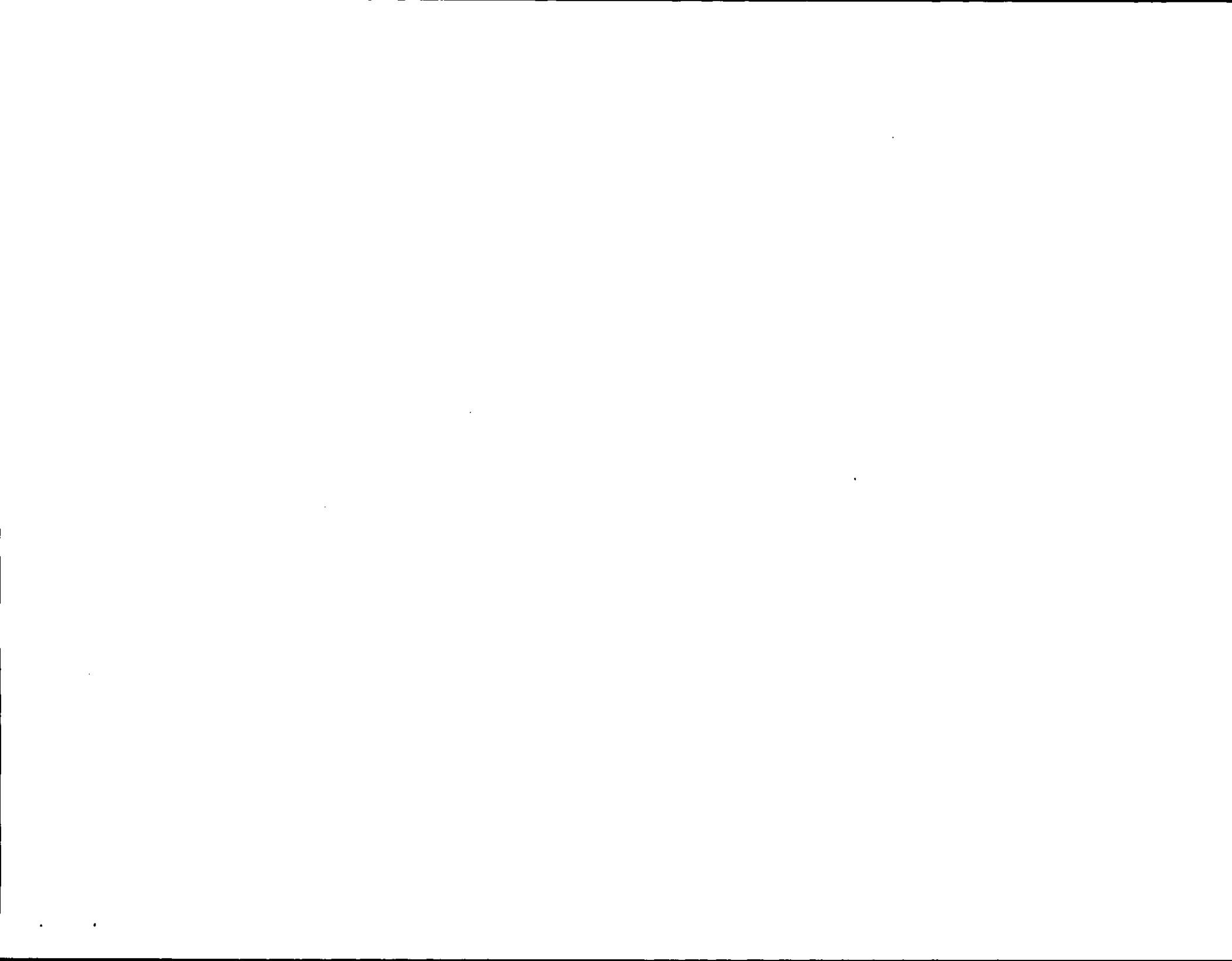
D4027-X RUBBER CUSHION

RELEASED  
2010-05-05  
MR

- NOTES:  
 1) MATERIAL: BLACK SOLID RUBBER NEOPRENE SHEET, 0.063 THICK  
     REF DART SPEC M-NEO-60-S.063  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.01 lbs

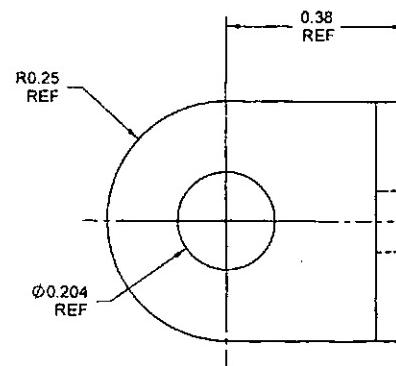
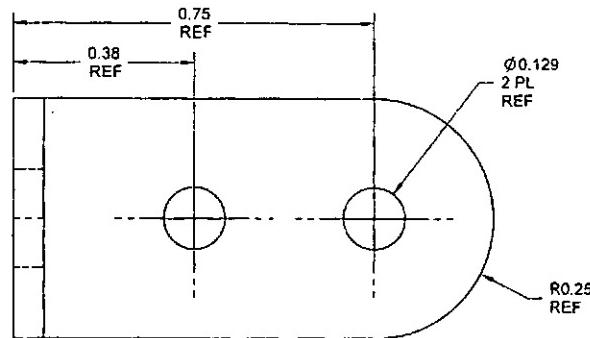
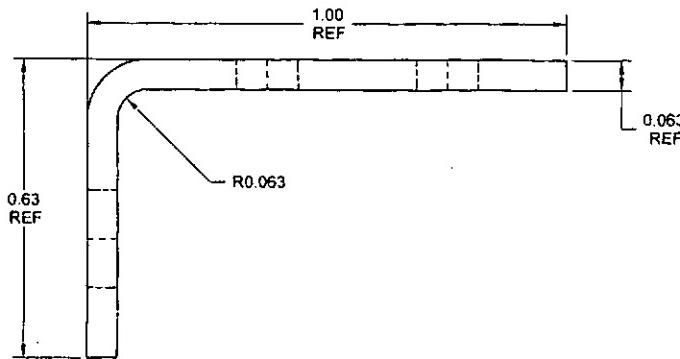
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DE APPR.	<i>[Signature]</i>	SHEET 5 OF 7
DATE	10.04.16	SCALE
		NTS
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8	7	6	5	4	3	2	1
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER						

D4027-9      REF JCA-M47-2-20/35

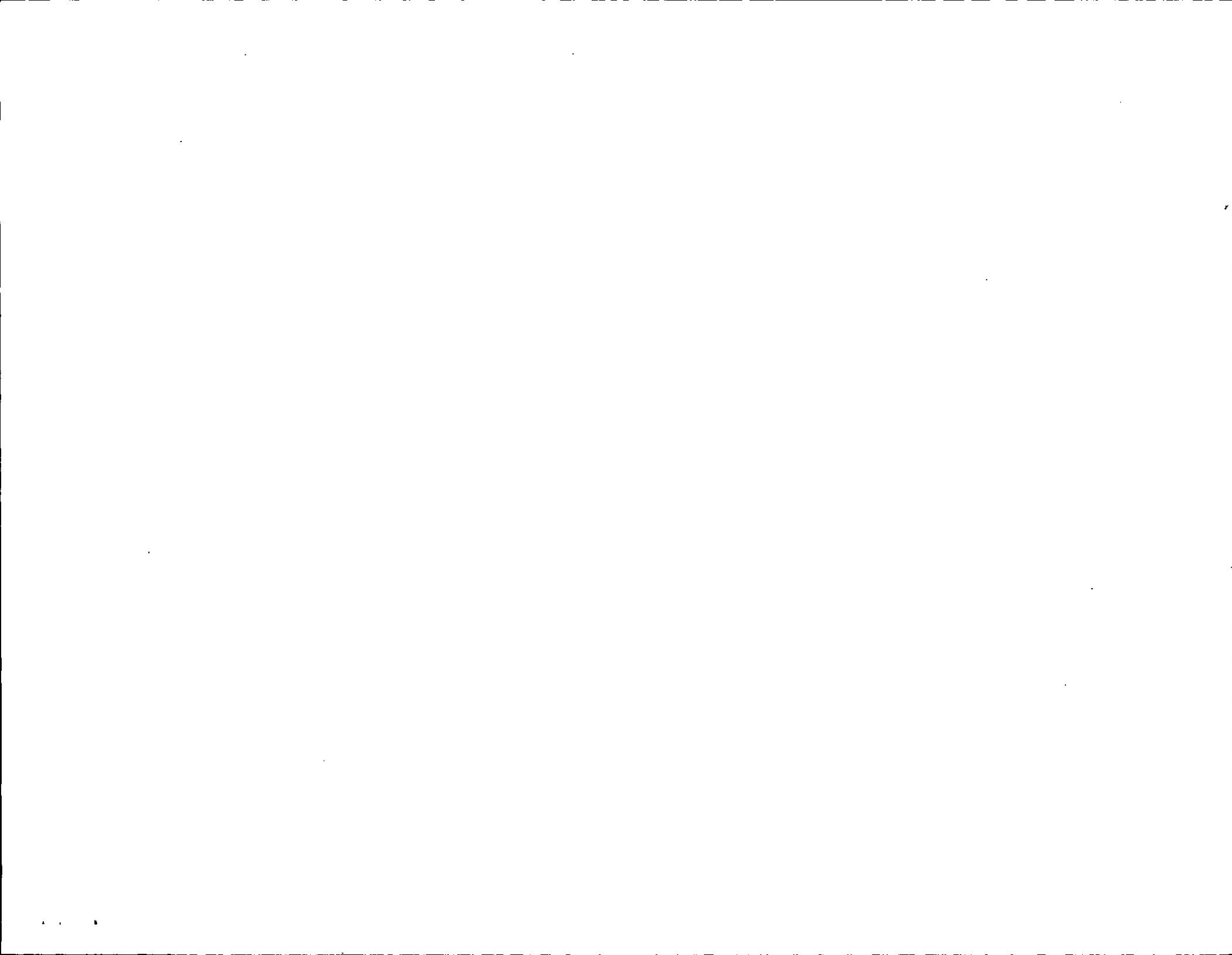


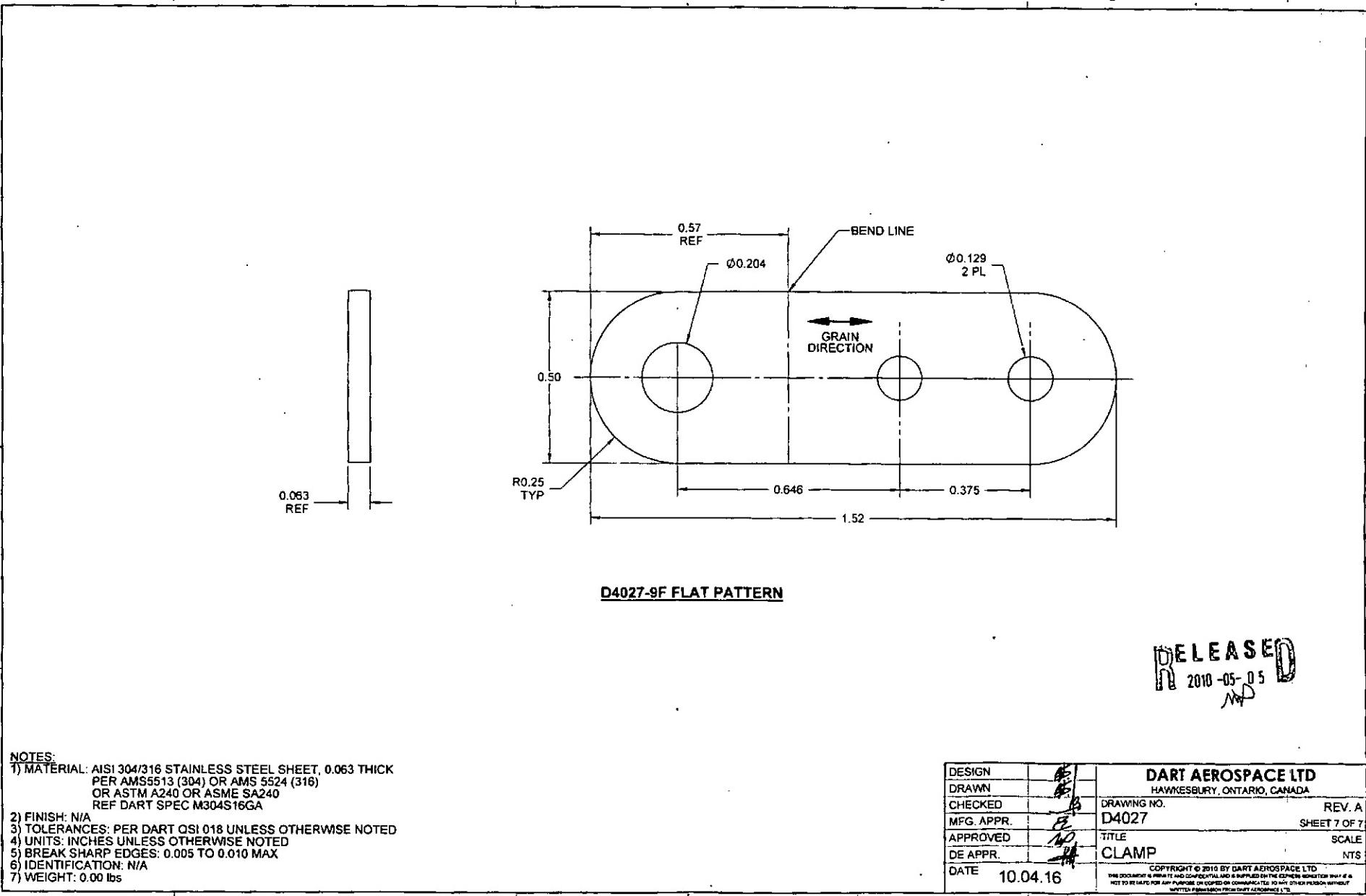
D4027-9 BRACKET, SUPPORT ANGLE

RELEASED  
R 2010-05-05  
MM

- NOTES:
- 1) MATERIAL: MADE FROM D4027-9F OR EQUIVALENT TO AN743-C13
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.00 lbs

DESIGN	<i>AS</i>	DART AEROSPACE LTD	
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MFG. APPR.	<i>AS</i>	DRAWING NO. D4027 SHEET 6 OF 7	
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2010-05-05  
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